

D 200628-022B1

BLUE

Dart Aerospace Ltd.

Date: Monday, 17/11/2008 10:39:47 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : 206L /407 STEP ASSY, RH
<b>Job Number</b> : 43478A	
<b>Estimate Number</b> : 11703	
<b>P.O. Number</b> :	<b>Part Number</b> : D2724042
<b>This Issue</b> : 17/11/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2724 REVC
<b>Prsht Rev.</b> : NC	<b>Project Number</b> :
<b>First Issue</b> : / / <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : C
<b>Previous Run</b> : 39838A	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> <i>skip</i> 15/12/2008 <b>Qty:</b> <i>4</i> Um: Each
<b>Checked &amp; Approved By</b> : <i>JUD 08.11.17</i>	
<b>Comment</b> : Est Rev:E As Per Ecn 766 06-01-06 JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D2622120C	Step Extrusion
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Qty	Part #	Description	Batch:
1	D2622-120C	Extrusion	<i>B42155</i>

Check Material for any Dents or Defects

*SAD**08-11-17**(4)*

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1

Cut D2724-2 using D2622 extrusion as per Dwg D2724  
 Deburr and bevel ends for welding

*SAD**08-11-17**(4)*

3.0	D2734	Step End Plate
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

206 Step Endplate

Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	<i>B39179</i>

*SP 08.11.19**(8x)*

4.0	D34581	Step Mounting Plate
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3458-1	Plate	<i>B 42635</i>

*SP 08.11.19**(8x)*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 17/11/2008 10:39:47 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 43478A

Part Number: D2724042

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	D34583	Step Mounting Plate
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty	Part Number	Description
2	D3458-3	Plate

Batch

B 42636

SP 08.11.19

(8X)

6.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Weld end cap and lugs as per Dwg D2724 using Jig DT followed by Jig

DT (One End Only)

A/R AL ROD Batch:

H 109213  
H 104855

SP 08.11.20

(4X)

Grind end cap welds flush

3AD

08-11-20

(40)

7.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

08/11/21

8.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

08/11/21

(+4 RV)

9.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FX 08/11/25

(4)

10.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/11/25

11.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

SP 08.11.25

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2724-042 PAR #: 08-044 Fault Category: Prod/FAB. Large NCR: Yes ☒ No ☐ DQA: D Date: 08/12/19  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/11/19	#60	<del>Free (x4)</del> 2 D3458-1 SCRAP 2 D3458-3 SCRAP P.C. had to be removed		Scrap and Destroy and replace D3458-1 B# <u>421635</u> (x2) D3458-3 B# <u>421636</u> (x2)				
		After tackling due to position being off. Lack of experience of welding this type of steps. * No welding sig -> process. *		Grind <del>step</del> MARKING / weld off step before repositioning <del>PAR already executed</del> PAR already opened to make a sig. PAR 08-044.				

NOTE: Date & initial all entries

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Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 43478A

Part Number: D2724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

Weld Remaining end cap as per Dwg D2724 using Jig DT followed by Jig

DT

A/R AL ROD Batch: M 104855

SP 08.11.25 (4)

Grind end plate flush.

12.0

QC9

VISUAL WELDING INSPECTION



(4)

Comment: VISUAL WELDING INSPECTION

Pl 08.11.26 SP 08.11.26

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sodul26 (4) RM

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(4)

Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

FL 08/11/27

15.0

SPRAY PAINTING

SPRAY PAINTING



Comment:

-PRIME

B 109992

-SPRAY PAINT DELFLEET BLUE B 105918

-CLEAR DELFLEET

B 109816

ml 08 12 03 (4)

16.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

08-12-04 (4)

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(4) X

Comment: Wing Walk as per Dwg D2724 and QSI 00 5 4.4

m-1 08/12/04

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-12-04 (4)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 43478A

Part Number: D2724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

POP 43478

JS 08/12/12 (x4)

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

JS 08/12/12

Job Completion



mf 08-12-12

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

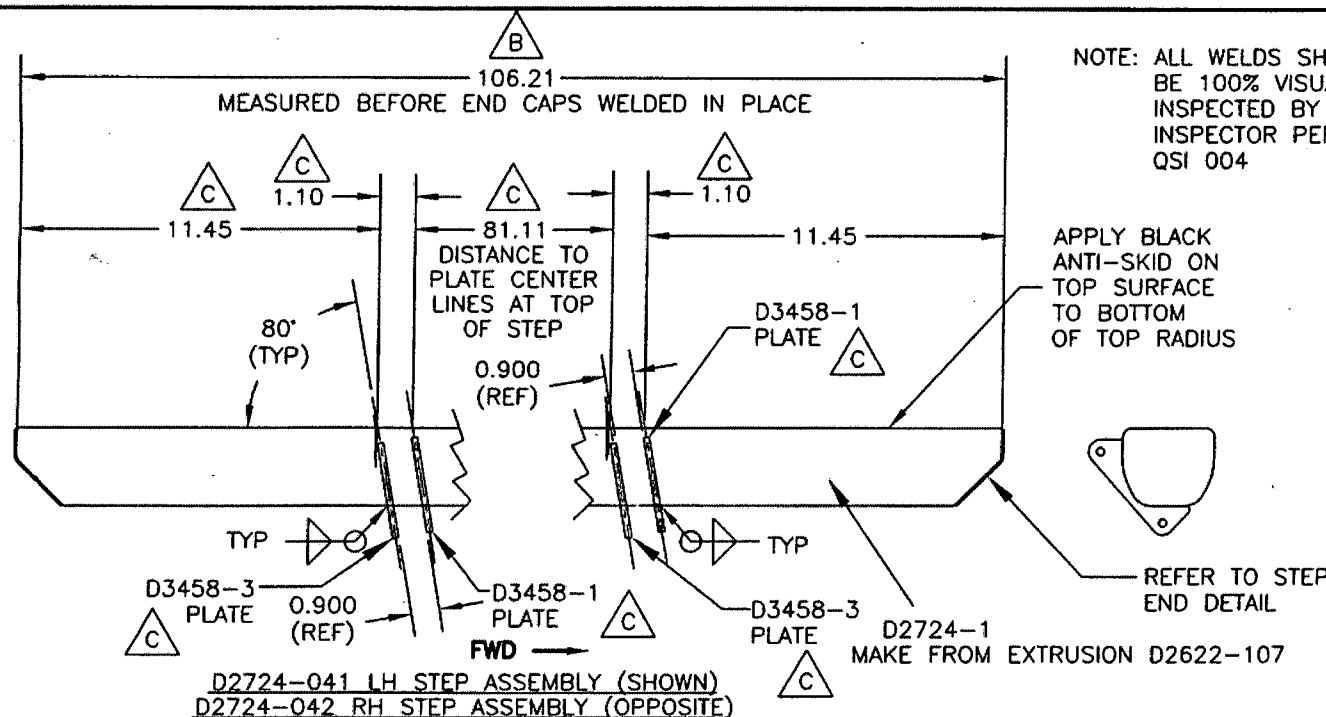




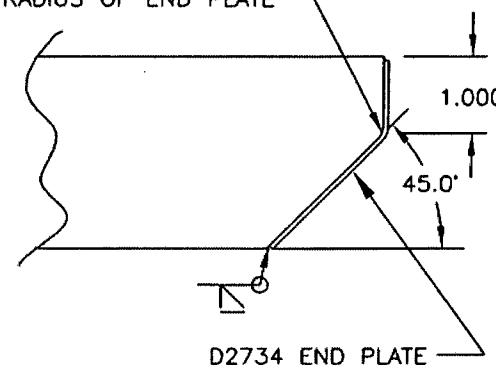
RELEASED  
05.11.14

11.45  
1.10  
1.10  
13.65  
81.11  
94.76  
1.10  
93.66

NOTE: ALL WELDS SHALL  
BE 100% VISUALLY  
INSPECTED BY A QUALIFIED  
INSPECTOR PER DART  
QSI 004



ROUND CORNER OF EXTRUSION TO  
MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL  
NOT TO SCALE

**D2721-041/-042 STEP ASSEMBLY PARTS LIST**

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X	X	D2724-041	LH STEP ASSEMBLY
		D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

WORK ORDER NO. 43512819  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
SHOP COPY  
RETURN TO  
ENGINEERING

**D2724-041/-042 STEP ASSEMBLY**

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	05.09.19	TITLE	206L/407 STEP ASSEMBLY	REV. C
	A		97.12.04	NEW ISSUE
	B		98.10.19	UPDATED WELD DETAIL REVISED TOLERANCES
	C		05.09.19	RE-DESIGN, ADD D3458-1/-3
				SCALE NTS